

Work Order ID 56727

March 5, 2010 9:59:52 AM



Page 1

Item ID: D3391-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PL

Date: 10-3-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H

100		0.00
	Skidtubes	
Skidtubes	Memo	0.00
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020	

1 10/3/9

110		0.00
	BENDING MACHINE - SKIDTUBES	
CNC Bend 1	Memo	0.00
CNC Delta 100 Bender	Bend as per Dwg D3391	

DP 10-3-10

120		0.00
	QC5- Inspect part completeness to step on W/O	
QC	Memo	0.00
Quality Control		

h = 6.625"
L = 12.90

8/10/3/10

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/07	130	the length the dimension 4.250 in too long of 0.15 in tolerance			10/03/07			

NOTE: Date & initial all entries

Work Order ID 56727

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Item ID: D3391-011

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Setup Start



Revision ID:

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Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>AA</u> & Dwg D3391 Rev. <u>H</u>								
	Identify as D3391-1								
	2-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
150		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	1-Drill .1875" at end of tube as per Dwg D3391								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 05/03/2010 Start Qty: 1.00



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Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

OK 10/03/27

1 2

170

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 10/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56727

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Item ID: D3391-011

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Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Skidtubes

Skidtubes

Skidtubes

0.00

Memo

0.00

1-Drill and c'sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(DRILL ALL HOLES)

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr and scribe batch # inside aft end

7- transfer drill D3391-011 with D3391-013

11/10/13/31

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/10/05

Memo

0.00

Q4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56727

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Item ID: D3391-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1300



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

* Part was left in ACD longer Due to Fire Evac.
Approx. 45 min *

1 4/12/14

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Scallos

(X)

220

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Install crossbolt spacers per dwg D3391
A/R Magnabond 6398 batch: 112417

4/12/16

2- Grind flush

Exe 11/1/30

3- back drill crossbolt if necessary

4/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

Work Order ID 56727



March 5, 2010 9:59:52 AM

Page 6

Item ID:	D3391-011	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Tube Assembly				Stop	
Start Date:	05/03/2010	Start Qty:	1.00			
Required Date:	17/03/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		


Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							

Quality Control

Re-Airline as per 09-043 → ml 10-08-16①

240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
									
Powdercoat									
Powder Coating	Memo	0.00							
	START TIME: 8:30am								
	OVEN TEMPERATURE: 320°C								
	FINISH TIME: 9:00am								

250	QC3- Inspect Part Finish	0.00							
									
QC	Memo	0.00							

Quality Control

ml 10 08 17 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56727

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Item ID: D3391-011

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Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 05/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260



Packaging

Identify as per dwg & Stock Location: W/O 56742

Memo

0.00



Packaging

270



Skidtubes

Skidtubes

0.00

Memo

0.00

x1 0

Skidtubes

**** install D3591-1 spacer as per DSI9364 ****

W

10/08/18

280



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/08/19

ME 10-8-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 5, 2010 9:59:50 AM

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Work Order ID: 56727



Parent Item: D3391-011



Parent Item Name: Fwd Tube Assembly

Start Date: 05/03/2010

Required Date: 17/03/2010

Comments: IPP A 05.09.13 New issue KJ/JLM

Start Qty: 1.00

Required Qty: 1.00

IPP B 06.02.09 Dwg rev.D EC

IPP C 07.03.13 revF dwg ec

IPP D 07.11.01 ecn1053P EC

D6013-047



Manufactured No

220

Each

47.0000

1.0000



Skidtube Material

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

47

23935

3

26547

44

11193/9

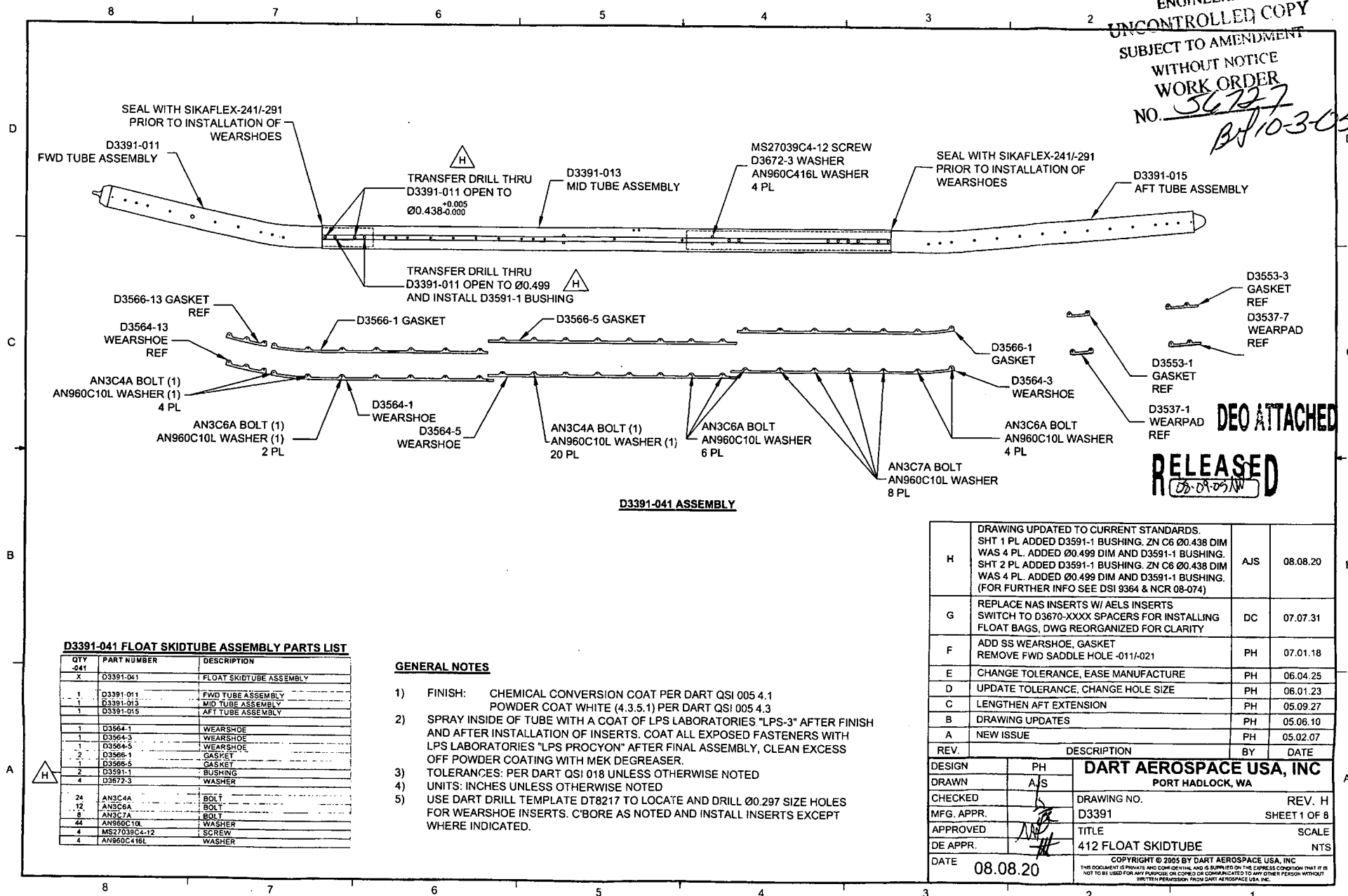
B391-011

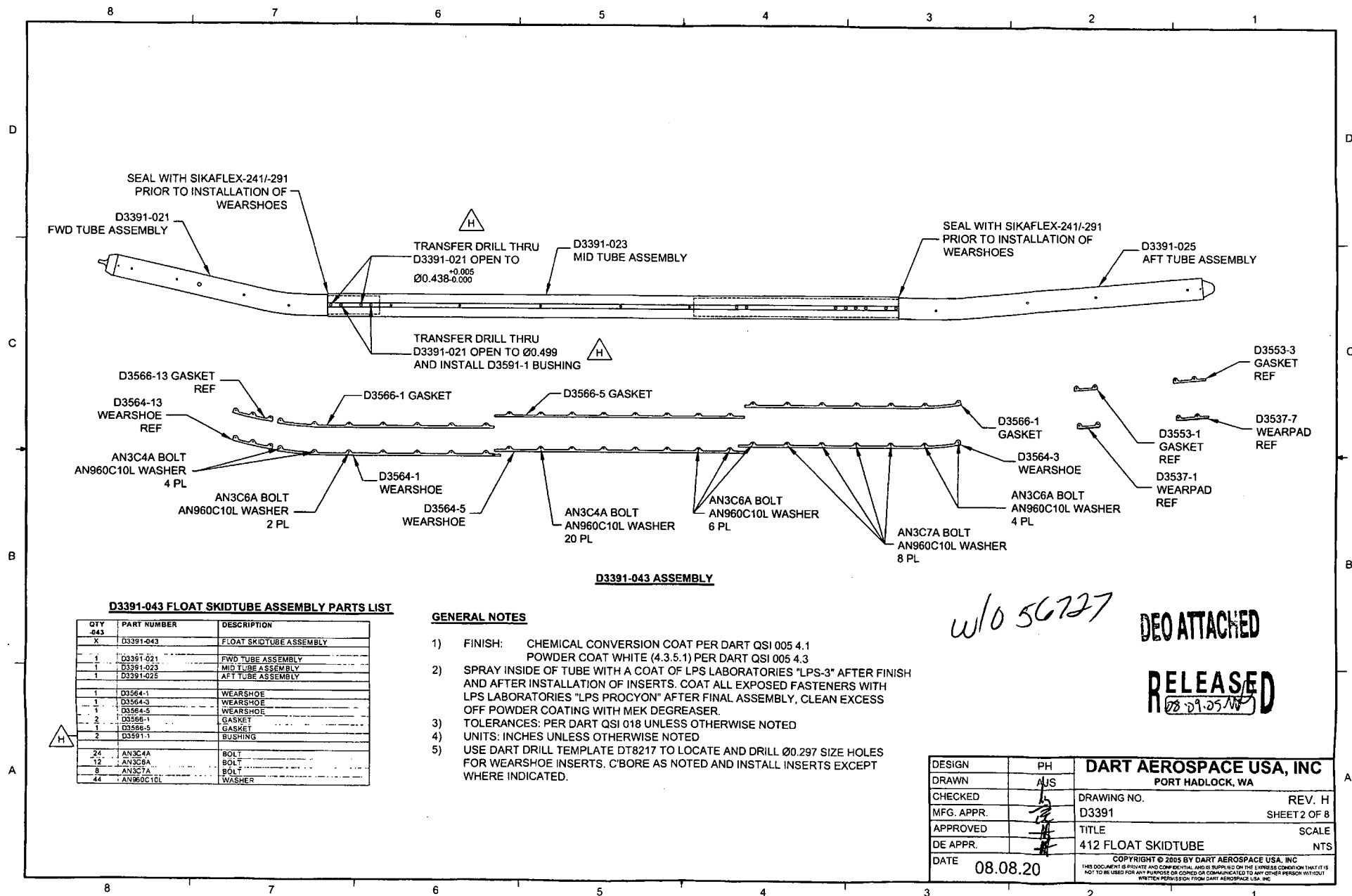
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✓	D6013-047		Skidtube Material	05/12/2009	1.0000		Each	0 %	100		1		05/12/2009 7:18 PM	05/12/2...
✓	D3401-041		Tow Cap Assembly	07/04/2010	1.0000		Each	0 %	255		2	X1	B41931	07/04/2... M
✓	D3564-13		Wearshoe	07/04/2010	1.0000		Each	0 %	255		3	X1	B59660	07/04/2... M
✓	D3566-13		Gasket	07/04/2010	1.0000		Each	0 %	255		4	X1	B59661	07/04/2... M
✓	D3670-4-200		SPACER	07/04/2010	9.0000		Each	0 %	220		5		B482694 B562015	07/04/2... K01412
✓	D3672-1		Phenolic Washer	07/04/2010	4.0000		Each	0 %	255		6	X4	B3520505	07/04/2... M
✓	AN3C4A		BOLT	07/04/2010	10.0000		Each	0 %	255		7	X10	M114941	07/04/2... M
✓	AN960C10L		washer	07/04/2010	10.0000		Each	0 %	255		8	X10	M115000	07/04/2... M
✓	AELS-1032-130		INSERT	07/04/2010	2.0000		Each	0 %	255		9	X2	M1114723	07/04/2... M
✓	AELS-1032-225		INSERT	07/04/2010	10.0000		Each	0 %	255		10	X10	M110768	07/04/2... M

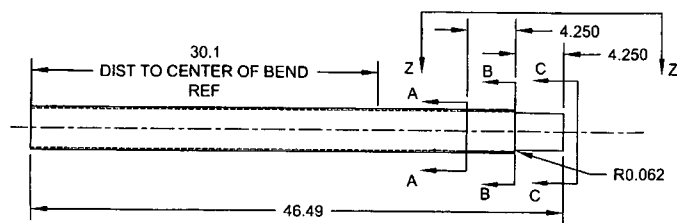
per m. change dd 10.04.07

M10108118 (41)

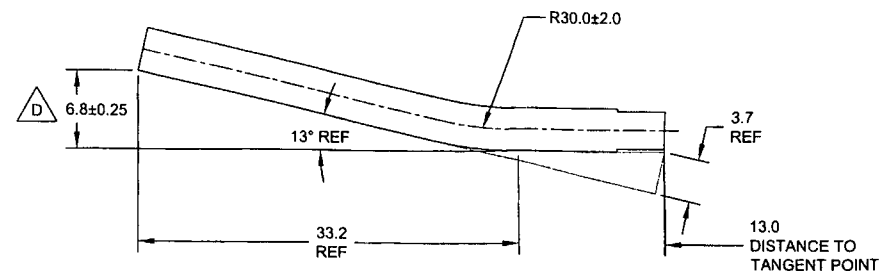
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36727
B-10-3-05



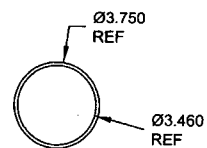




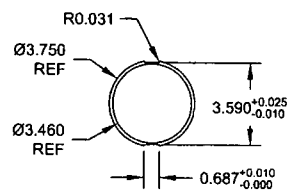
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



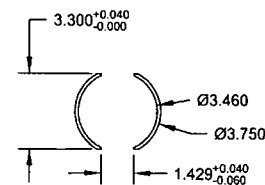
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



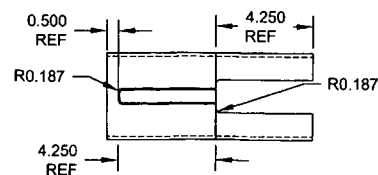
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SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

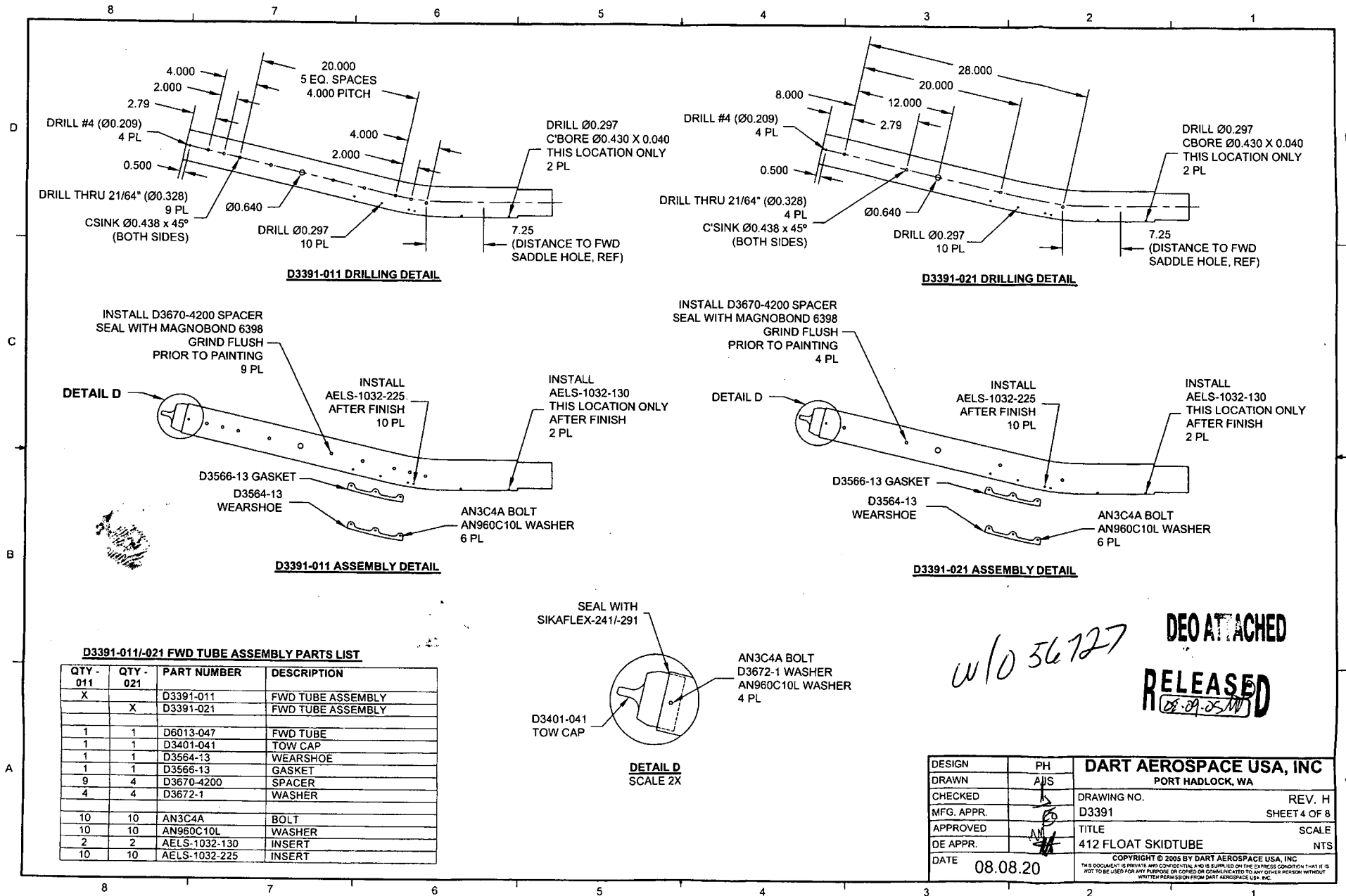


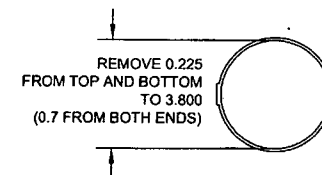
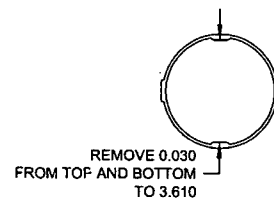
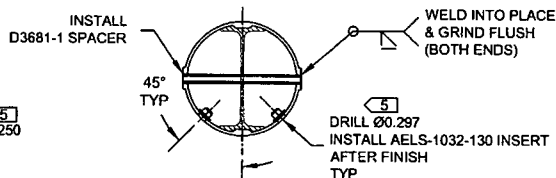
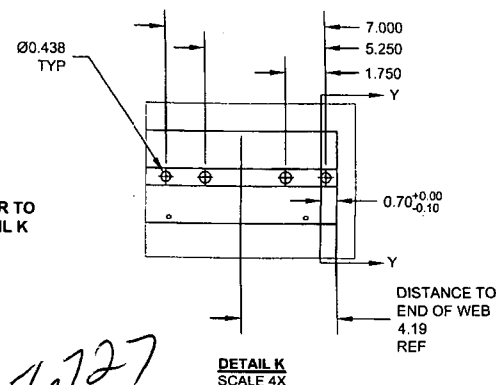
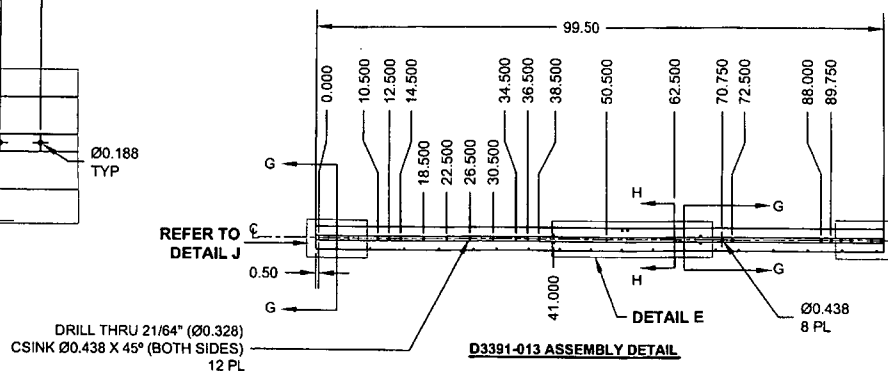
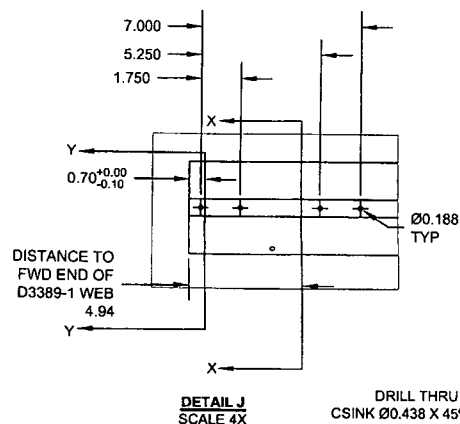
VIEW Z-Z
SCALE 2X

W/056727

DEO ATTACHED
RELEASED
28 JUL 05

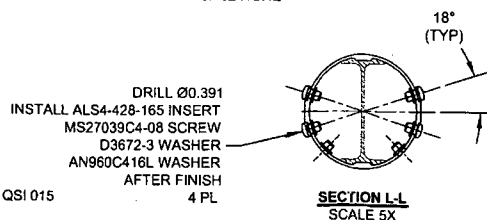
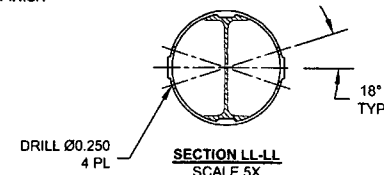
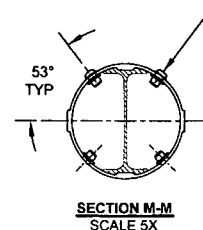
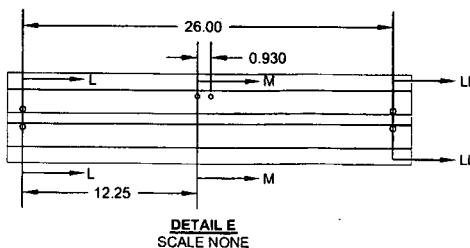
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D3391	REV. H SHEET 3 OF 8
MFG. APPR.	6	TITLE 412 FLOAT SKIDTUBE	SCALE NTS
APPROVED	ANN	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
DE APPR.	TH	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	
DATE	08.08.20		






D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



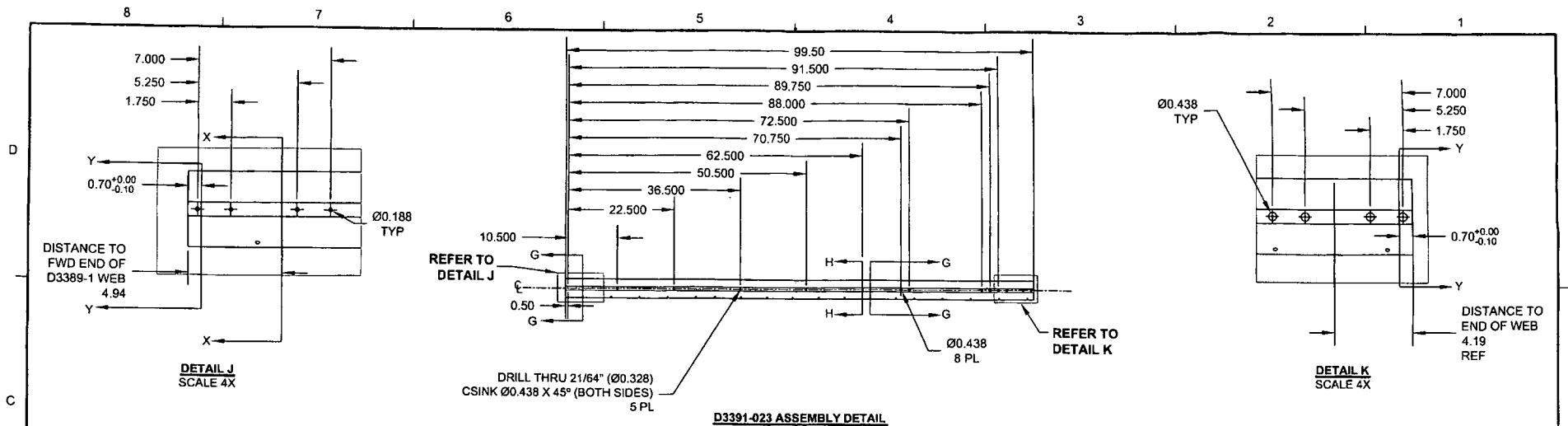
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

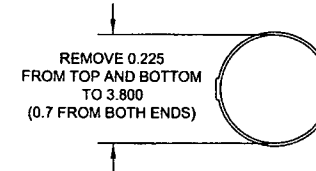
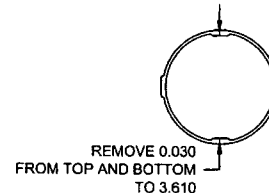
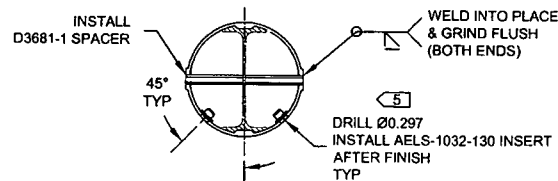
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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W/056727

DEO ATTACHED
RELEASED



W/0 56727







D3391-023 MID TUBE ASSEMBLY PARTS LIST

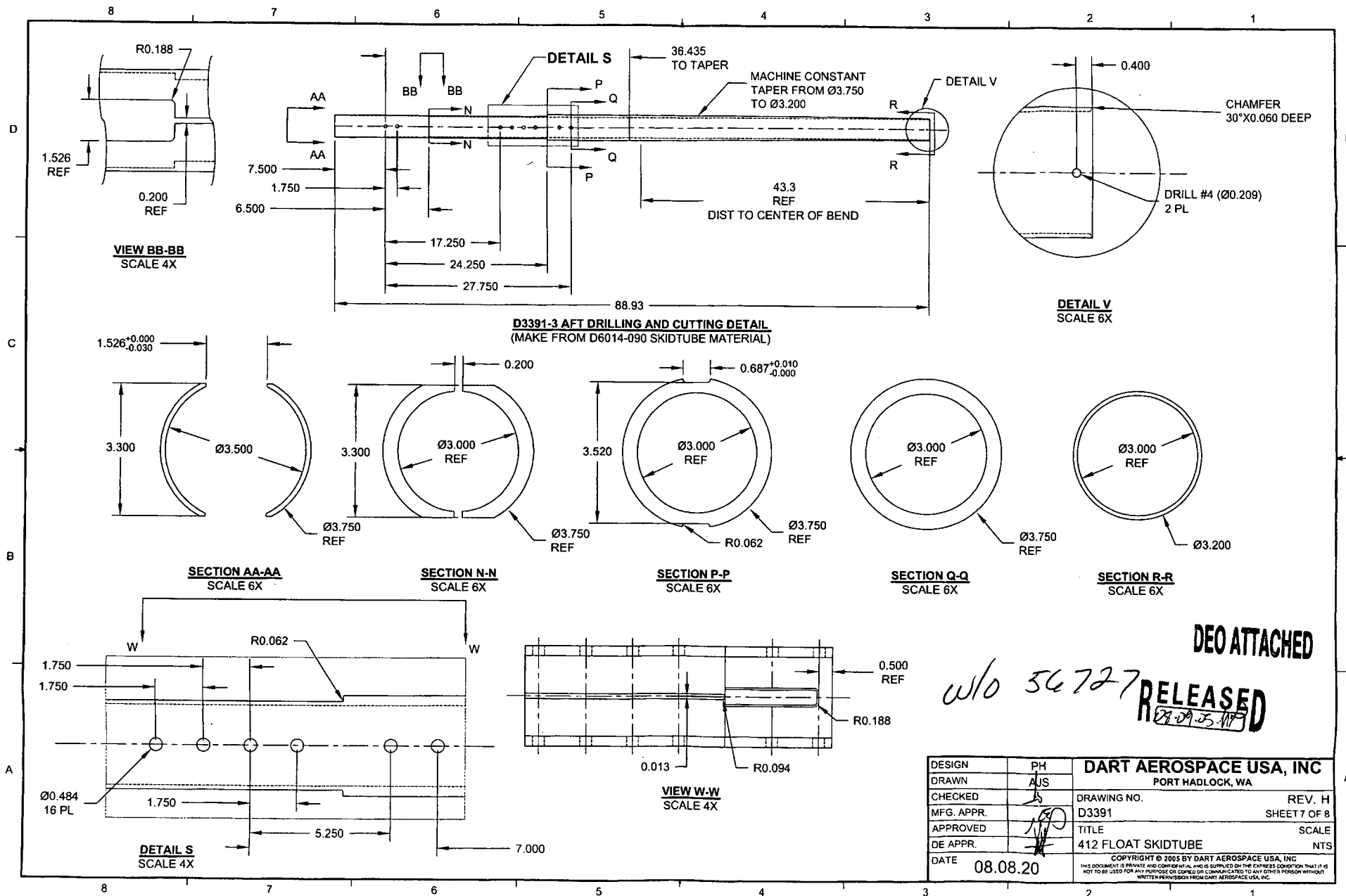
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

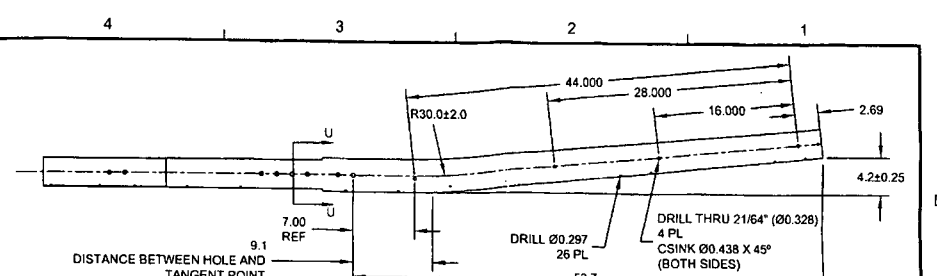
DEO ATTACHED
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

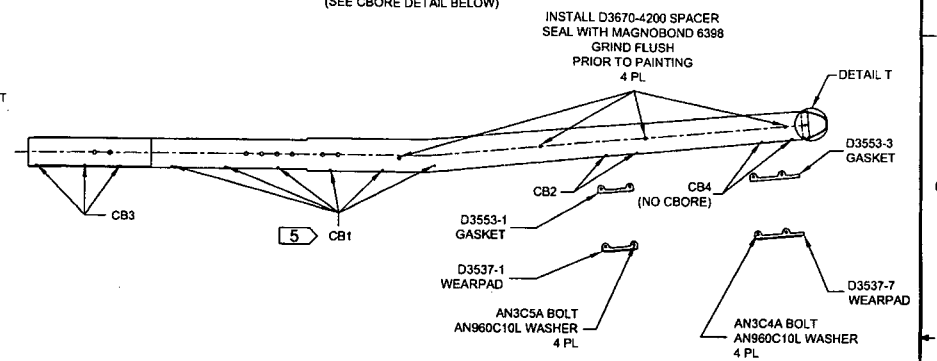


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w/o 56727
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28-09-05-117

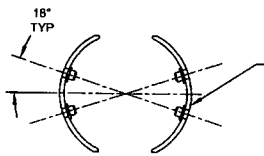


D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

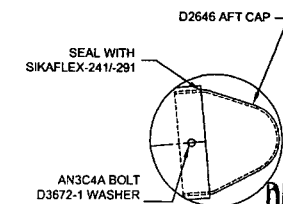


D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3CA4	BOLT
4	4	AN3CSA	BOLT
10	10	AN860C10L	WASHER



SECTION CC-CC
SCALE 3X



DETAIL T
SCALE 4X

DEO ATTACHED

RELEASED
08-09-05 M

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 09.09.23	DATE 04.04.24	DATE 09/09/25	DATE 09/09/30		DATE 09/09/30		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02

MP

w/0 36727

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